

Work Order ID 81536

March-15-12 10:29:46 AM

81536

Page 1

Item ID: D3197-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bar Assembly

Start Date: 15/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 23/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/15

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3197	Rev B

100 0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 29.125" long

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

I-Face ends to lenght per dwg D31972-Machine D3197-1 as per Folio FA340 and Dwg D31973-Deburr

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81536

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N900040100

Setup Start ***NS1***

Stop *NS2*

6

6

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

130

0.00

SL 12/03/28

140

0.00

6 6 ~~2~~
12/63/29

0.00

150

0.00

Hand Finishing

6 ~~B~~ 12-3-29.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 81536

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March-15-12 10:29:46 AM

Item ID: D3197-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bar Assembly
 Start Date: 15/03/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 23/03/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
160						6	0	(2P)	12/03/20
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 7h15 FINISH TIME: 8h45	OVEN TEMPERATURE: 320°F		m117338					
170	QC3- Inspect Part Finish	0.00							
170						6	AR 12.330.		
QC	Memo	0.00							
Quality Control									
180	Small Fab	0.00							
180									
Small Fab	Memo	0.00							
Small Fab	Assemble D3197-041 as per Dwg D3197								

EP 12/04/02 (6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 81536

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Item ID: D3197-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bar Assembly
 Start Date: 15/03/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 23/03/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		81264/02		(46)			
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>260</u> Memo	0.00 0.00				JB	(6)	12/04/03	
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00						12/4/13	df

12-04-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

March-15-12 10:29:51 AM

Page 1

Work Order ID: 81536

81536

Parent Item: D3197-041

D3197-041

Parent Item Name: Bar Assembly

Start Date: 15/03/2012

Required Date: 23/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev: A New Issue 05-11-08 JLM
IPP Rev: B As per Rev B 06-03-10 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS27039-1-24

Purchased

No

100

Each

58.0000

2

12

MS27039-1-24

Screw

**

Location

Loc Qty

Loc Code

ST292

58

100151

58

AN960JD10

NAS1149D0363J

Purchased

No

180

Each

0.0000

6

36

AN960JD10

Washer

**

D2690-5

Manufactured

No

180

Each

5.0000

2

12

D2690-5

Lanyard Assembly

**

Location

Loc Qty

Loc Code

ST013

5

79514

5

D3242-1

Manufactured

No

180

Each

16.0000

2

12

D3242-1

Tag

**

Location

Loc Qty

Loc Code

ST

16

79825

16

EP 12/04/02

12

EP 12/04/02

12

EP 12/04/02

5

B8540 (7a)

EP 12/04/02

12

12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

March-15-12 10:29:51 AM

Page 2

Work Order ID: 81536

Parent Item: D3197-041

Parent Item Name: Bar Assembly

81536

D3197-041

Start Date: 15/03/2012

Required Date: 23/03/2012

Start Qty: 6.00

Required Qty: 6.00

D3489-3-200

Manufactured No

180 Each

12.0000 2 12

D3489-3-200

PIP PIN

**

Location

Loc Qty

Loc Code

GA

12

75792

3

79862

9

M7075T73R1.000

Purchased No

180 f

69.3750 2.42 18.15

M7075T73R1 000

7075-T73 Rd Bar 1.00

**

Location

Loc Qty

Loc Code

MAT012

69.375

120503

21.375

120568

48

MS21042L3

Purchased No

180 Each

3,091.000 2 12

MS21042L3

Nut

**

Location

Loc Qty

Loc Code

ST300

3091

117441

16

117885

32

118451

5

118927

3

119017

2862

119075

173

EB 12/04/02
B81884 (3x)

16 ~~12~~ 12/03/28
EB 12/04/02

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	81536
Description: Bar		Part Number:	D3197-1
Inspection Dwg: D3197 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	29.00	✓		Vern	SL-1
25.06	+/-0.030	25.06	✓		"	
11.44	+/-0.030	11.44	✓		m-jape	
0.500	+/-0.010	.501	✓		Vern	SL-1
0.250	+/-0.030	.260	✓		"	
Ø0.219	+0.005/-0.000	.220	✓		"	
Ø0.191	+0.005/-0.000	.191	✓		"	
1.000	+/-0.005	1.000	✓		"	
2.69	+/-0.030	2.685	✓		├	
1.000	+/-0.010	1.000	✓			
0.300	+/-0.010	.301	✓			
0.063 x 45°	+/-0.010	.063x45°	✓			
Ø1.000	+/-0.010	.998	✓			

Measured by:	SL	Audited by:	BL	Prototype Approval:	N/A
Date:	12/03/28	Date:	12/03/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3197-041)	KJ/JLM	
B	07.03.09	Dwg revision update	KJ/JLM	BE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

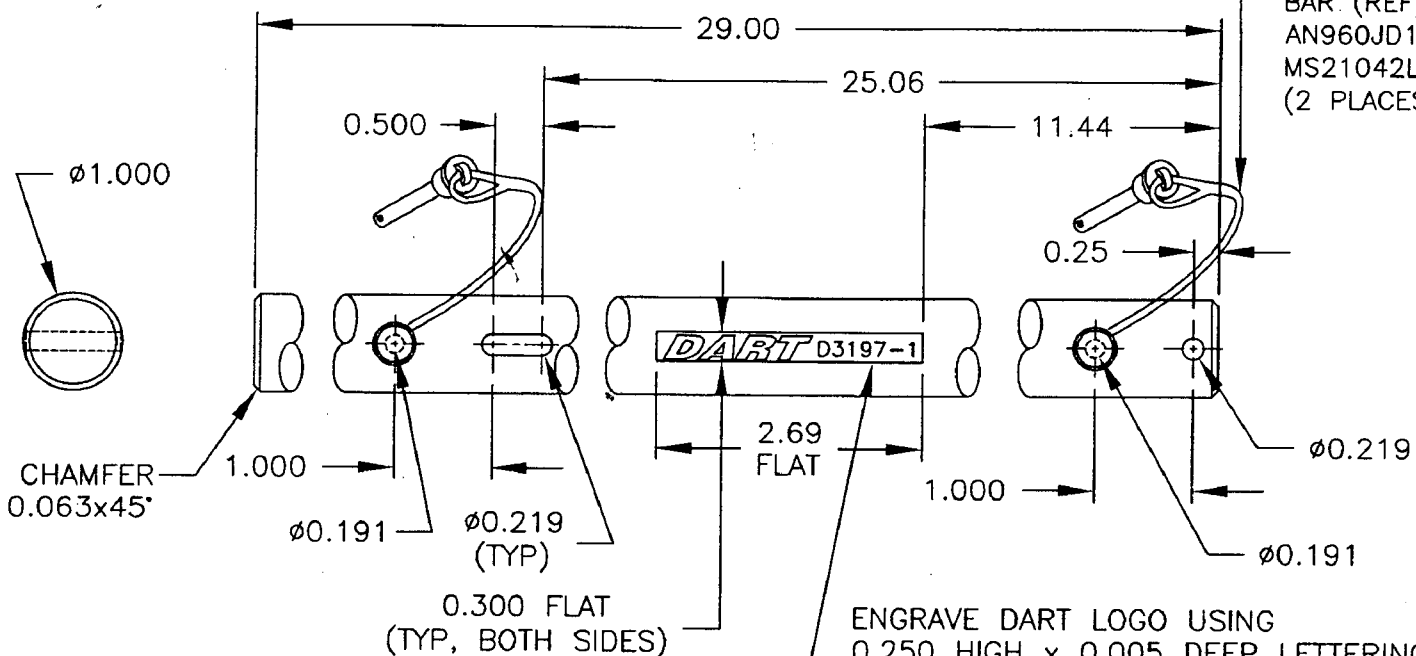
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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RELEASED

DART

D3489-3-200 PIP PIN (1)
D3242-1 TAG (1)
MS27039-1-24 BOLT (1)
AN960JD10 WASHER (1)
D2690-5 LANYARD (1)
AN960JD10 WASHER (1)
BAR (REF)
AN960JD10 WASHER (1)
MS21042L3 NUT (1)
(2 PLACES)



D3197-041 BAR ASSEMBLY

ENGRAVE DART LOGO USING
0.250 HIGH x 0.005 DEEP LETTERING
AND P/N USING 0.150 HIGH x 0.005
DEEP LETTERING ON BOTH SIDES

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 81536 MLJ

12/03/15

DESIGN	DRAWN BY	DART AEROSPACE LTD
CP	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3197
DATE	TITLE	REV. B
06.01.10	BAR	SHEET 1 OF 1
A	03.07.01	NEW ISSUE
B	06.01.10	CHG PIP PIN; ADD D3242-1 TAG
		SCALE 1:1

D3197-1 BAR

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9) ϕ 1.000 O.D. (REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER END OF THE BAR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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